



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2572
Job Sheet 191025



Part No: D2572

Job Qty: 12 pcs

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: ~~Stock~~ **SOLD**

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	3/18/19		0.62	19.35	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SDC/WHB 19/4/22
							HAAS - 4		
110	Conventional Mill - 1 - B4B	12 pcs	3/18/19		0.00	0.00	Conventional Mill - 1 - B4B		WHB 19/4/22
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	3/18/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		WHB 19/4/22
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S172278



Part: D2572

Job No: 191025

Serial No/Batch: S172278

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/15/19

Plex 2/20/19 2:53 PM Dart.lajeunesse.marie

130 QC 8	12 pcs	3/18/19	0.00 0.00	QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	DR 19/04/22
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
140 Handfinish - 1-1 Chemical-B4B	12 pcs	3/18/19	0.00 0.49	QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR 19/04/24
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	

				Handfinish - 1 - 22 - B4B		
150	Powdercoat - 1 White GI(A)- B4B	12 pcs	3/18/19	0.00	0.46	Powdercoat - 1 - B4B
						Powdercoat - 2 - B4B
						Powdercoat - 3 - B4B
						Powdercoat - 4 - B4B
160	QC 3	12 pcs	3/18/19	0.00	0.00	QC 3 - 10
						QC 3 - 13
						QC 3 - 15
						QC 3 - 17
						QC 3 - 18
						QC 3 - 2
						QC 3 - 26
						QC 3 - 28
						QC 3 - 3
						QC 3 - 30
						QC 3 - 34
						QC 3 - 36
						QC 3 - 41
						QC 3 - 51
						QC 3 - 58
						QC 3 - 59
						QC 3 - 6
						QC 3 - 68
						QC 3 - 9
170	Packaging 3-1 - Stock - B4B	12 pcs	3/18/19	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 - B4B
						Packaging 3 - 30 - B4B
						Packaging 3 - 31 - B4B
						Packaging 3 - 32 - B4B
						Packaging 3 - 33 - B4B
						Packaging 3 - 34 - B4B

BL 19-4-24

START 2:10 O.T. 3:30 FINISH - 2:40

DAS
40
9-89

APR 24 2019

5+397 APR 25 2019

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	12 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. _____ Double check by: _____ 1-Machine Step No 1
 Descriptions: per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp
 110 - (Manufacture as per dwg) Machine keyway as per dwg D2571 & D2572
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	12 pcs (1 ea)	100-HAAS 4 Axis	5147786

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-005	12	22	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Inboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Fwd Inboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Fwd Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
11	Saddle, Fwd Inboard	0.558Inches + 0.020 - 0.000	0.578 0.558		
12	Saddle, Fwd Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
13	Saddle, Fwd Inboard	1.490Inches + 0.010 - 0.000	1.500 1.490		
14	Saddle, Fwd Inboard	2.495Inches + 0.010 - 0.000	2.505 2.495		
15	Saddle, Fwd Inboard	3.869Inches + 0.010 - 0.000	3.879 3.869		
16	Saddle, Fwd Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
17	Saddle, Fwd Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
18	Saddle, Fwd Inboard	0.240Inches + 0.020 - 0.000	0.260 0.240		

19	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD	Work Order: 191 025
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.7500		
E	7.990	8.010		7.999	7.998	7.999	7.998		
F	0.490	0.510		0.499	0.499	0.498	0.496		
G	0.257	0.262	✓	0.258	0.257	0.257	0.257		
H	0.375	0.380	✓	0.376	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.498	0.500	0.498		
J	1.174	1.184	✓	1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5695	0.567	0.568	0.566		
L	1.174	1.184	✓	1.179	1.179	1.179	1.179		
M	1.490	1.500	✓	1.495	1.495	1.495	1.495		
N	2.495	2.505	✓	2.500	2.500	2.500	2.500		
O	3.869	3.879	✓	3.874	3.874	3.874	3.874		
P	0.115	0.135		0.135	0.135	0.135	0.132		
Q	0.115	0.135		0.126	0.125	0.125	0.125		
R	0.240	0.260		0.252	0.253	0.253	0.253		
S	0.115	0.135		0.133	0.130	0.127	0.129		
T	0.178	0.198	✓	0.188	0.188	0.188	0.188		
U	2.940	2.980	✓	2.956	2.956	2.956	2.956		
V	0.230	0.250		0.241	0.244	0.241	0.243		
W	0.115	0.135		0.125	0.129	0.130	0.1325		
X	0.307	0.312		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.3615	0.365	0.363	0.361		
AA	0.470	0.530	✓	0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.065	0.070		
AD	0.240	0.260		0.252	0.255	0.251	0.253		
AE	1.375	1.395	✓	1.385	1.385	1.385	1.385		
AF	0.115	0.135	✓	0.128	0.132	0.135	0.135		
AG	0.240	0.280	✓	0.260	0.260	0.260	0.260		
AH	0.240	0.260	✓	0.245	0.24	0.248	0.250		
AI	2.000	2.020	✓	2.000	2.000	2.000	2.000		
AJ	0.023	0.043	✓	0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: VAB	Audited by: [Signature]
Date: //	Date: 19/04/30

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 191 025
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 5	2 6	3 7	4 8		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.997	7.997	7.998	7.998		
F	0.490	0.510		0.494	0.497	0.495	0.496		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.501	0.4985	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.570	0.5655	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.130	0.130	0.135	0.135		
Q	0.115	0.135		0.125	0.125	0.125	0.126		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.129	0.131	0.131	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.958	2.960	2.960		
V	0.230	0.250		0.241	0.241	0.243	0.241		
W	0.115	0.135		0.132	0.133	0.133	0.130		
X	0.307	0.312		0.311	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.362	0.365	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.6235	0.624		
AC	0.053	0.073		0.063	0.065	0.065	0.065		
AD	0.240	0.260		0.250	0.252	0.253	0.251		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.248	0.251	0.250	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>VHS</i>
Date: 19/04/22

Audited by: <i>Oni</i>
Date: 19/04/23

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 191025
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 ₉	2 ₁₀	3 ₁₁	4 ₁₂	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.997	7.998	7.999		
F	0.490	0.510		0.498	0.498	0.501	0.498		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.498	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.565	0.567	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.129	0.126	0.125	0.124		
R	0.240	0.260		0.253	0.253	0.253	0.253		
S	0.115	0.135		0.130	0.129	0.130	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	0.240	0.242	0.243		
W	0.115	0.135		0.133	0.133	0.124	0.133		
X	0.307	0.312		0.311	0.312	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.359	0.364	0.363	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.624	0.624	0.624		
AC	0.053	0.073		0.063	0.070	0.066	0.060		
AD	0.240	0.260		0.253	0.250	0.254	0.254		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.250	0.250	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>VHR</i>
Date: 19/4/22

Audited by: <i>Am</i>
Date: 19/04/23

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	